

Date: Monday, 3/26/2007 2:48:31 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR DOUBLER	
Job Number	: 31508				
Estimate Number	: 12680				
P.O. Number	: N/A		Part Number	: D35941	
This Issue	: 3/26/2007	S.O. No. : <i>ML</i>	Drawing Number	: D3594 UNDER REVIEW	
Prsht Rev.	: NC		Project Number	: AC0001	
First Issue	: 3/26/2007	Type : SMALL /MED FAB	Drawing Revision	: U/R	
Previous Run	: 30495		Material	: N/A	
Written By	<i>JLM</i> 07-03-26.		Due Date	: 4/2/2007	
Checked & Approved By			Qty:	1 Um: Each	
Comment	: Est Rev :A New Issue 07-01-22 EC				

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet  <div style="text-align: center;"> <b>CERTIFICATE OF CONFORMITY</b>  <b>REQUIRED</b> </div>
		Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.0578 sf(s) 6061-T6 .080 Sheet Batch: <i>M101178 ML 07 03 27</i>
2.0	WATER JET	FLOW WATER JET  <div style="text-align: center;"> </div>
		Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: <i>U/R</i> <i>ML 07 03 27</i> Prog Rev: <i>U/R</i>
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <div style="text-align: center;"> </div>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <div style="text-align: center;"> </div>
4.0	QC8	SECOND CHECK  <div style="text-align: center;"> <b>ENGINEERING APPROVAL</b>  <i>07-03-27</i> </div>
		Comment: SECOND CHECK  <div style="text-align: center;"> </div>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  <div style="text-align: center;"> </div>
		Comment: SMALL & MEDIUM FAB RESOURCE 1  <div style="text-align: center;"> </div>
		Deburr if necessary.  <div style="text-align: center;"> </div>

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Description :

6.0 QC5



ENGINEERING

APPROVAL

07.04.30



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

WIA WU 00071

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

07.04.30

Job Completion



U 07-04-30

(1)

S.1

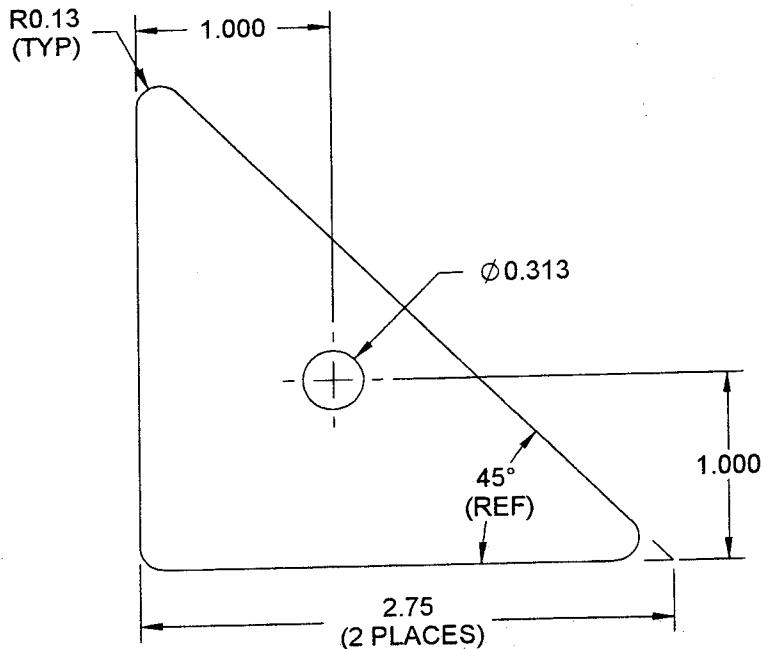
Alodine IAW QSI

#005 4.1

070430

**PRELIMINARY ISSUE**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>P/H</i>	APPROVED	DRAWING NO. D3594	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE DOOR DOUBLER	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	



**D3594-1 DOOR DOUBLER**

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

*L/T  
Dave*

DART AEROSPACE LTD	Work Order:	31508
Description: Door Doubler	Part Number:	D3594-1
Inspection Dwg: D3594 Rev: V/R		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø 0.313	+0.005 -0.001	0.314	✓		VERN	
B 1.000	+1-0.010	1.002	✓		VERN	
C 1.000	+1-0.010	1.003	✓		VERN	
D 0.080	+1-0.010	0.078	✓		VERN	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M.H.	Audited by:	R	Prototype Approval:	N/A
Date:	07.03.21	Date:	07.07.21	Date:	N/A 07.07.21

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	